

Date: Thursday, 9/14/2006 4:32:32 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE, OUTBOARD, LH, 206
Job Number	: 28601		
Estimate Number	: 10818		
P.O. Number	: <i>N/A</i>	Part Number	: D26651
This Issue	: 9/14/2006	S.O. No.	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Number	: D2665 REV. C
First Issue	: <i>N/A</i>	Project Number	: N/A
Previous Run	: 28404	Drawing Revision	: C
	Type : MACHINED PARTS	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 9/30/2006
Checked & Approved By	: <i>[Signature]</i>	Qty:	8 Um: Each
Comment	: Est: C 0011.01 Removed P/O for Powder Coat - in house processEC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101003	7075-T7351 2X6.25X7.875
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
 7075-T7351 2X6.25X7.875
 Cut Size 2.0" x 6.25" x 7.88"
 Grain Along Long 7.88 Length Batch no *B25348* *SA* *8*

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Program batch number.
 1-Inspect part number and batch number are programmed correctly.
 3-Fixturing Inspection last completed on *06/09/16* by *J.L.*
 4-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet
 5-Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet
 6-Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet
 7- Deburr */J.L. 06/09/16 8*

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
 Machine Keyway and inspect per attached dimension sheet *J.L. 06/09/16 8*

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE *J.L. 06/09/16 8*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
06/09/21		-dimension S should be changed to .316 on drawing - " " on FAT should be .316 min and .321 max - a new GO-NO GO gauge and ST # should be made See attached DS email	J.L	06/09/21		CP 06.09.21 per QSI 042		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 06/09/26
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 9/14/2006 4:32:32 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, OUTBOARD, LH, 206

Job Number: 28601

Part Number: D26651

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

ml 06/09/17

8

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SAD 06:09:17

8

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FC 06 09 18

8

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

CG 4/9/19

8

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: ST482

RB 06/09/19

8

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/09/26

Job Completion



U 06/09/19

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	28601
Description: 206 Saddle, Outboard, Left side	Part Number:	D2665-1
Inspection Dwg: D2665 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.122	.122	.121	.121		
B	0.100	0.140		.123	.123	.121	.123		
C	1.125	1.145		1.136	1.136	1.136	1.133		
D	0.615	0.685		.665	.665	.665	.665		
E	0.240	0.260		.250	.250	.250	.254		
F	1.313	1.343		1.327	1.327	1.328	1.327		
G	0.210	0.230		.221	.221	.221	.222		
H	0.100	0.180		.138	.140	.140	.140		
I	2.470	2.510		2.498	2.495	2.495	2.495		
J	1.565	1.585		1.573	1.573	1.573	1.570		
K	0.235	0.240		.239	.239	.239	.239		
L	0.100	0.120		.120	.120	.117	.116		
M	0.990	1.010		1.000	1.000	1.001	1.001		
N	0.510	0.515		.514	.514	.514	.514		
O	5.990	6.010		6.000	6.002	6.002	6.003		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318	DT 8686	.314	/	/	/		
S	0.313	0.318		.318	/	/	/		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		.795	.796	.796	.796		
W	0.540	0.560		.549	.550	.551	.550		
X	1.674	1.684		1.675	1.679	1.679	1.678		
Y	0.257	0.262	DT 8683	.258	/	/	/		
Z	0.912	0.932		.924	.922	.923	.923		
AA	0.490	0.510		.500	.501	.500	.500		
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	SA / JL
Date:	06/05/15 / 06/09/16

Audited by:	me
Date:	06/09/17

Rev	Date*	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD	Work Order: 28601
Description: 206 Saddle, Outboard, Left side	Part Number: D2665-1
Inspection Dwg: D2665 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. C and record below:

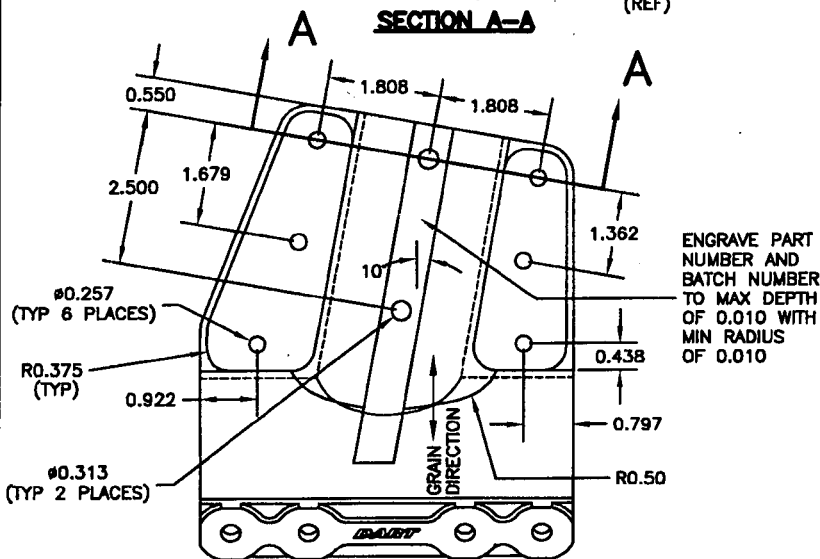
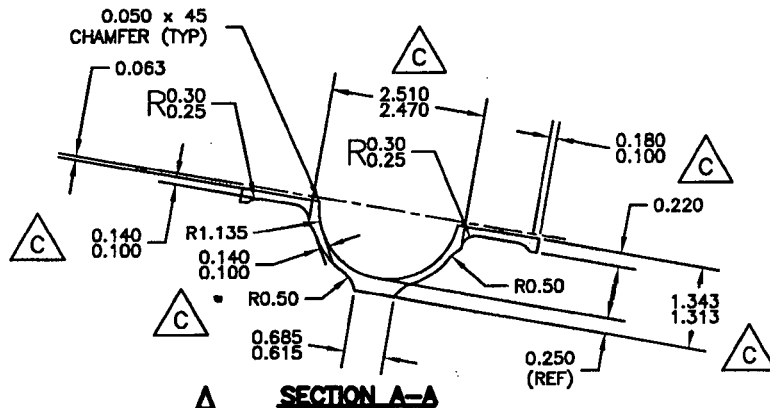
				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.122	.121	.123	.121		
B	0.100	0.140		.122	.124	.123	.123		
C	1.125	1.145		1.135	1.135	1.135	1.134		
D	0.615	0.685		.665	.665	.665	.665		
E	0.240	0.260		.253	.252	.254	.253		
F	1.313	1.343		1.327	1.328	1.328	1.328		
G	0.210	0.230		.222	.222	.223	.222		
H	0.100	0.180		.140	.140	.140	.140		
I	2.470	2.510		2.495	2.495	2.495	2.495		
J	1.565	1.585		1.571	1.571	1.571	1.571		
K	0.235	0.240		.239	.239	.239	.239		
L	0.100	0.120		.114	.114	.113	.113		
M	0.990	1.010		1.001	1.001	1.001	1.001		
N	0.510	0.515		.514	.514	.514	.514		
O	5.990	6.010		6.003	6.003	6.003	6.003		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		/	/	/	/		
S	0.313	0.318		/	/	/	/		
T	2.495	2.505		2.499	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		.797	.797	.798	.798		
W	0.540	0.560		.551	.553	.552	.551		
X	1.674	1.684		1.679	1.679	1.678	1.679		
Y	0.257	0.262		/	/	/	/		
Z	0.912	0.932		.924	.925	.924	.924		
AA	0.490	0.510		.500	.500	.500	.501		
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: J.L.	Audited by: ml
Date: 06/09/16	Date: 06/09/17

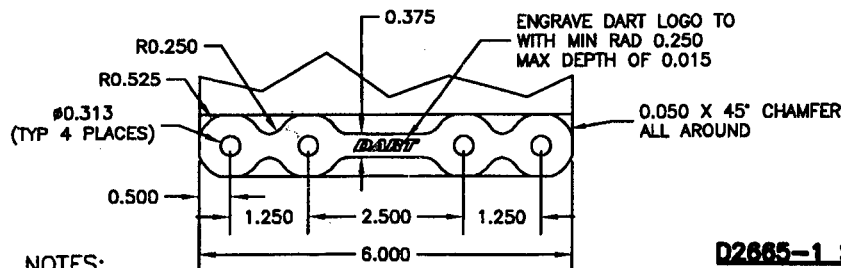
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	

DART

DESIGN #	DRAWN BY C.B.	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED #	APPROVED #	DRAWING NO. D2665	REV. C SHEET 1 OF 1
DATE 06.05.29		TITLE SADDLE FWD OUTSIDE HIGH	SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.29	INCORPORATE DEO 9122, 9102, 9095	



ENGRAVE PART
NUMBER AND
BATCH NUMBER
TO MAX DEPTH
OF 0.010 WITH
MIN RADIUS
OF 0.010

**NOTES:**

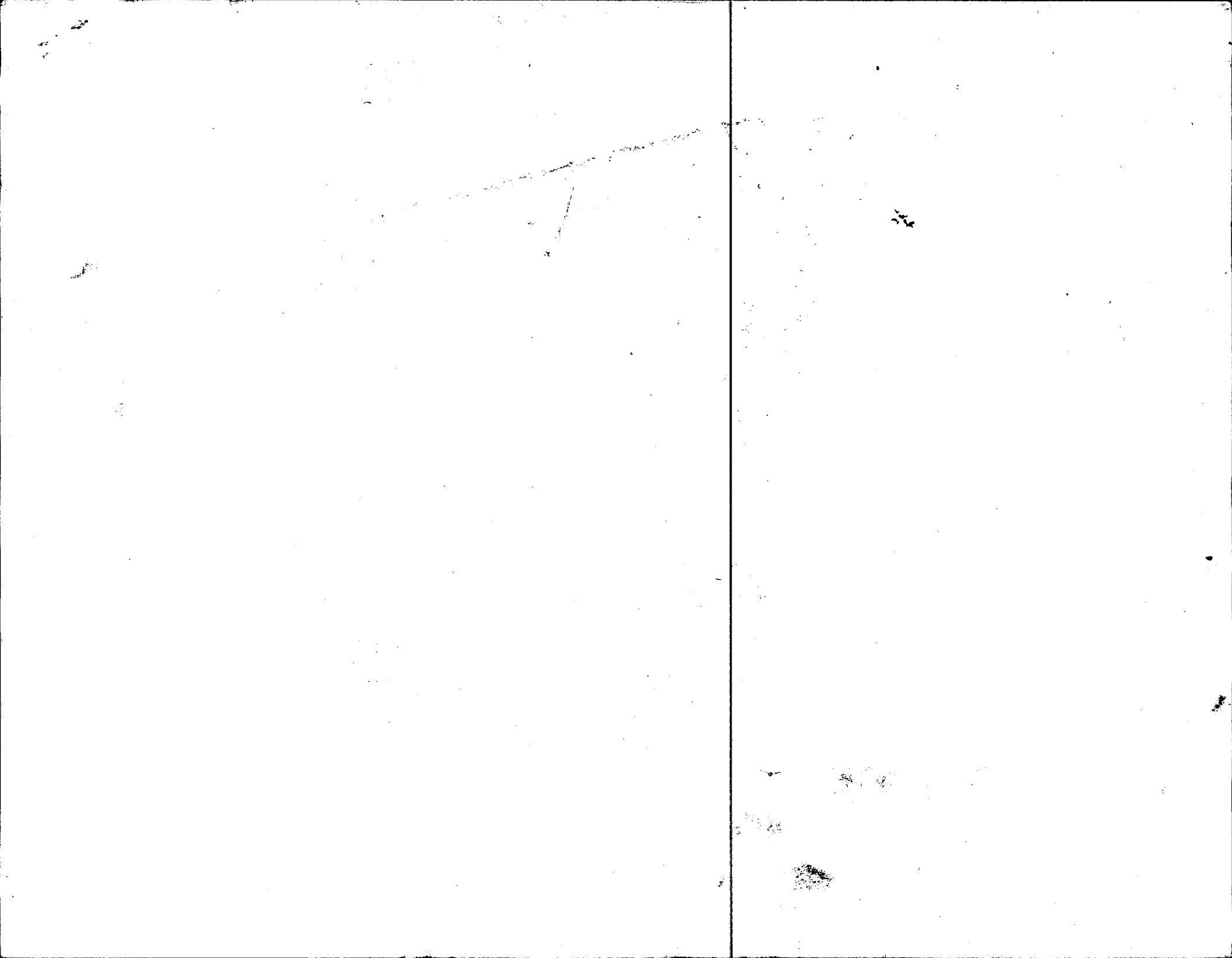
- 1) MATERIAL: 7075-T7351 (QQ-A-250/12) (REF DART SPEC M7075T73B)
- 2) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE PER DART QSI 005 4.3.5.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2665-1 SHOWN (D2665-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES

D2665-1 SADDLE FWD OUTSIDE HIGH

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 28601

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Chris Provencal

From: David Shepherd [dshepherd@dartaero.com]
Sent: September 21, 2006 2:58 PM
To: 'Chris Provencal'
Cc: 'C Bell'; 'S Shahbazian'
Subject: RE: D2665 Saddle

This is acceptable.

For some reason, I thought someone was in the process of fixing these drawings (Chris Bell?)

In fact, I may have already signed them.

Please look into it.

David

From: Chris Provencal [mailto:cprovencal@dartaero.com]
Sent: Thursday, September 21, 2006 7:26 AM
To: David Shepherd (David Shepherd)
Subject: D2665 Saddle

David,

The two 0.313 OD saddle-to-crosstube holes, the dwg says 0.313, the folio is evidently calling for a 0.316 drill. The 0.316 is required to fit the part on the tooling, they must have been using 0.316 for some time. Anyhow, they want the drawing changed to 0.316 (I don't see a big problem with that), but for now they need an email to sign of this latest batch as a deviation on the work order. Ultimately this would affect all the 206 saddles. Is 0.316 OD acceptable for the saddle-to-crosstube holes on the D2665 saddles?

Chris

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No virus found in this incoming message.

Checked by AVG Free Edition.

Version: 7.1.405 / Virus Database: 268.12.5/451 - Release Date: 9/19/2006

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No virus found in this outgoing message.

Checked by AVG Free Edition.

Version: 7.1.405 / Virus Database: 268.12.6/453 - Release Date: 9/20/2006

21/09/2006